

Work Order ID 125924

Friday, October 24, 2014 2:17:00 PM

125924

Page 1

Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle
Start Date: 10/24/14 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 11/28/14 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan:  Date: 11-10-24 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3500	C

100	HAAS CNC VERTICAL MACHINING #1	0.00				40	0		
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100
HAAS 1
HAAS CNC vertical machine #1
Memo
Program Batch No. 125924 Double check by: 1-Machine Step No 1
per Folio FA641 and inspect per attached Dimension Sheets2-Machine Step
No 2 per Folio FA641 and inspect per attached Dimension Sheets3-Machine
Step No 3 per Folio FA641 and inspect p

110	QC2- Inspect parts off machine FAI/FAIB	0.00				40	0		
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110
QC
Quality Control
Memo

120	QC8- Inspect parts - second check	0.00				40	0		
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120
QC
Quality Control
Memo

DAS
08
9-83

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 125924

Friday, October 24, 2014 2:17:00 PM

125924

Page 2

Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle
Start Date: 10/24/14 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 11/28/14 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per OSI005 4.1	0.00							
130	HandFinish	0.00				40	1		
Hand Finishing	Memo								
140	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum	0.00							
140	Powdercoat	0.00				40	0	14-12-16	DAS 34 9-88
Powder Coating	Memo								
	START TIME: 2:00 OVEN TEMPERATURE:								
	FINISH TIME: 2:30								
150	QC3- Inspect Part Finish	0.00							
150	QC	0.00				40	5		DAS 38 9-89
Quality Control	Memo								

→ PTO
JAN 13 2015

DQA:

Date: 15/03/19



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/03/19

Work Order update only ☐

Work Order: <u>125924</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3500-1</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-4659</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				found at inspection that saddle had scratch in powder coat		strip & re powder coat	CR 14.12	DAS 9 9-89	
Doc/Data							22	14.12.22	
Equip/Tooling									
Handling/Pre	✓ 14.12	140	⑤						
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									
				RC. handling	15/01/13	Paint scraper M: 11/12/10/1 Powder coat START: 3:45. OCEW. T: 3:20 FINISH: 4:15.	5 15-1-12. 3:38	DAS 38 9-89 JAN 13 2015	15/01/13.

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☒ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 125924***125924***

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Friday, October 24, 2014 2:17:00 PM

Item ID: D3500-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle

Start Date: 10/24/14 Start Qty: 40.00

40

Cust Item ID:

Required Date: 11/28/14 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>538</u>	0.00				<u>40</u>			DAS
160									05
Packaging	Memo	0.00							9-09
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

JAN 16 2015

15/1/19 4015-1-19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, October 24, 2014 2:18:00 PM

Page 3

Work Order ID: 125924

125924

Parent Item: D3500-1

D3500-1

Parent Item Name: Saddle

Start Date: 10/24/14

Required Date: 11/28/14

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6102-013

Manufactured No

100

Each

108.0000

1

40

D6102-013

Saddle Billet

Location

Loc Qty

Loc Code

MAT040

32

104299

22

105554

10

MAT042

20

~~121061~~

20

20

MAT044

20

120357

20

MAT046

36

109518

10

10

110225

6

110994

8

111533

12

125927

10

gm 11/11/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART AEROSPACE LTD		Work Order:	125 924
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.484	.484	.484	.484		
B	1.175	1.185		1.186	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.186	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.591	1.591	1.588	1.5895		
J	0.240	0.260		.246	.246	.246	.246		
K	0.490	0.510		.498	.498	.498	.499		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.055	.055	.055	.055		
Y	0.100	0.120		.108	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.135	1.135	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.252	.252	.252	.253		
AE	1.810	1.830		1.821	1.820	1.820	1.820		
AF	0.240	0.260		.253	.253	.253	.252		
AG	0.140	0.160		.153	.153	.153	.151		
AH	0.140	0.160		.156	.156	.156	.155		
AI	0.140	0.160		.157	.157	.157	.155		
Accept/Reject				✓	✓	✓	✓		

Measured by: <i>SMF</i>	Audited by: <i>MA</i>	DAS
Date: 14/11/23	Date: 14/11/24	08
		9-85

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<i>MA</i>

DART AEROSPACE LTD		Work Order:	125 924
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.590	1.589	1.591	1.588		
J	0.240	0.260		.245	.245	.246	.246		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.508	6.509	6.509	6.509		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.053	.055	.055	.055		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.134	1.135	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.252	.252	.250	.253		
AE	1.810	1.830		1.822	1.820	1.820	1.820		
AF	0.240	0.260		.253	.253	.253	.253		
AG	0.140	0.160		.153	.152	.153	.153		
AH	0.140	0.160		.153	.155	.154	.156		
AI	0.140	0.160		.153	.155	.155	.156		
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	14/11/24

Audited by:	A.A	DAS
Date:	14/11/24	08
		985

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	125 924
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	π_9	π_{10}	π_{11}	π_{12}	By	Date
A	0.483	0.490		.486	.486	.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	0.375		
F	0.490	0.510		.500	.500	.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.590	R1.587	R1.585	R1.586		
J	0.240	0.260		.246	0.248	0.248	0.247		
K	0.490	0.510		.500	.500	.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	0.316		
N	0.256	0.262		.258	.258	.258	0.258		
O	6.500	6.520		6.509	6.509	6.509	6.509		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	0.549	0.551	0.549		
V	0.793	0.803		.798	.798	.798	0.798		
W	R.240	R.260		.250	.250	.250	0.250		
X	0.040	0.060		.055	0.055	0.055	0.055		
Y	0.100	0.120		.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.132	R1.134	R1.134	R1.134		
AB	R.490	R.510		.500	.500	.500	0.500		
AC	0.615	0.635		.630	.630	.630	0.630		
AD	0.240	0.260		.252	0.253	0.254	0.254		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.252	.252	.252	0.252		
AG	0.140	0.160		.152	.152	.151	0.151		
AH	0.140	0.160		.157	0.157	0.155	0.155		
AI	0.140	0.160		.157	0.157	0.157	0.157		
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	14/11/24 / 14/11/25

Audited by:	<i>[Signature]</i>	DAS
Date:	14/11/29	08
		9-89

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	125 924
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	X 13	X 14	X 15	X 16	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		R 1.589	R 1.585	R 1.585	R 1.588		
J	0.240	0.260		0.248	0.248	0.248	0.247		
K	0.490	0.510		0.500	0.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.258	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.509	6.509	6.509	6.509		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.547	0.547	0.547	0.547		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.055	0.055	0.055	0.055		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		R 1.135	R 1.136	R 1.134	R 1.134		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		0.254	0.254	0.253	0.254		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.252	0.252	0.252	0.252		
AG	0.140	0.160		0.154	0.150	0.150	0.150		
AH	0.140	0.160		0.156	0.156	0.154	0.155		
AI	0.140	0.160		0.157	0.157	0.156	0.157		
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	14/11/25

Audited by:	A. A.	DAS
Date:	14/11/29	06
		9-89

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 125924
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	A 17	A 18	A 19	A 20	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		R 1.588	R 1.588	R 1.588	R 1.586		
J	0.240	0.260		0.248	0.247	0.248	0.247		
K	0.490	0.510		0.500	0.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.509	6.509	6.509	6.509		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.544	0.547	0.547	0.548		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.055	0.055	0.055	0.055		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		R 1.133	R 1.134	R 1.135	R 1.131		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		0.248	0.248	0.248	0.248		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.254	0.254	0.254	0.252		
AG	0.140	0.160		0.150	0.150	0.150	0.150		
AH	0.140	0.160		0.154	0.157	0.156	0.155		
AI	0.140	0.160		0.151	0.157	0.154	0.159		
Accept/Reject									

Measured by: <i>[Signature]</i>
Date: 14/11/25

Audited by: <i>[Signature]</i>	DAS
Date: 14/11/29	08
	9-83

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	125924
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
				21	22	23	24		
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		R 1.585	R 1.587	R 1.589	R 1.586		
J	0.240	0.260		0.248	0.248	0.248	0.248		
K	0.490	0.510		0.500	0.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.509	6.509	6.509	6.509		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.549	0.549	0.549	0.549		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.055	0.055	0.055	0.055		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		R 1.133	R 1.135	R 1.135	R 1.134		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		0.254	0.254	0.254	0.254		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.248	0.247	0.249	0.250		
AG	0.140	0.160		0.150	0.150	0.150	0.150		
AH	0.140	0.160		0.156	0.156	0.156	0.156		
AI	0.140	0.160		0.157	0.157	0.157	0.157		
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	14/11/26

Audited by:	A.A	DAS
Date:	14/11/29	08
		9-89

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	125 924
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
				25	26	27	28		
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.500	0.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		R 1.588	R 1.587	R 1.587	R 1.587		
J	0.240	0.260		0.248	0.247	0.248	0.248		
K	0.490	0.510		0.500	0.500	0.500	0.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.509	6.509	6.509	6.509		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.548	0.549	0.549	0.549		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.055	0.055	0.055	0.055		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		R 1.135	R 1.135	R 1.134	R 1.134		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		0.254	0.254	0.254	0.254		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.251	0.251	0.247	0.247		
AG	0.140	0.160		0.150	0.150	0.150	0.150		
AH	0.140	0.160		0.154	0.158	0.156	0.156		
AI	0.140	0.160		0.157	0.157	0.157	0.157		
Accept/Reject									

Measured by: <u>[Signature]</u>	Audited by: <u>D.A.</u>	DAS
Date: <u>14/11/29</u>	Date: <u>14/11/29</u>	08
		9-83

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	125 924
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
				29	30	31	32		
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.179	1.179	1.179	1.179		
C	3.145	3.155		3.149	3.149	3.149	3.149		
D	1.175	1.185		1.179	1.179	1.179	1.179		
E	0.365	0.385		.372	.372	.372	.372		
F	0.490	0.510		.499	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.598	1.588	1.588	1.590		
J	0.240	0.260		.245	.245	.251	.260		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.615	3.615	3.615	3.615		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.259	.259	.259	.259		
O	6.500	6.520		6.512	6.509	6.510	6.510		
P	5.990	6.010		6.003	6.000	5.998	6.004		
Q	2.820	2.830		2.826	2.832	2.826	2.825		
R	2.495	2.505		2.500	2.499	2.500	2.498		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.545	.549	.546	.545		
V	0.793	0.803		.800	.797	.798	.797		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.055	.05	.05	.05		
Y	0.100	0.120		.109	.108	.105	.110		
AA	R1.125	R1.145		1.135	1.135	1.127	1.140		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.628	.630	.630	.625		
AD	0.240	0.260		.253	.258	.260	.255		
AE	1.810	1.830		1.822	1.821	1.820	1.825		
AF	0.240	0.260		.252	.253	.250	.254		
AG	0.140	0.160		.152	.150	.151	.154		
AH	0.140	0.160		.153	.155	.155	.155		
AI	0.140	0.160		.151	.152	.153	.155		
Accept/Reject									

Measured by:	<i>P</i> 4/11/28	Audited by:	<i>HA</i>	DAS
Date:		Date:	4/11/29	08
				9-88

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	125 924
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.483	0.490		33 .486	34 .486	35 .486	36 .486		
B	1.175	1.185		1.178	1.179	1.179	1.179		
C	3.145	3.155		3.149	3.149	3.149	3.149		
D	1.175	1.185		1.178	1.179	1.179	1.179		
E	0.365	0.385		.377	.377	.377	.377		
F	0.490	0.510		.501	.500	.500	.501		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.590	1.592	1.588	1.588		
J	0.240	0.260		.248	.246	.249	.251		
K	0.490	0.510		.501	.501	.501	.501		
L	3.590	3.650		3.615	3.615	3.615	3.615		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.259	.259	.259	.259		
O	6.500	6.520		6.510	6.511	6.510	6.507		
P	5.990	6.010		5.997	5.998	5.999	5.995		
Q	2.820	2.830		2.826	2.826	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.251	2.250	2.250	2.250		
T	1.120	1.130		1.126	1.125	1.125	1.125		
U	0.540	0.560		.544	.544	.545	.542		
V	0.793	0.803		.797	.798	.797	.797		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.05	.054	.055	.055		
Y	0.100	0.120		.110	.107	.106	.104		
AA	R1.125	R1.145		1.138	1.141	1.137	1.137		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.628	.630	.628	.630		
AD	0.240	0.260		.256	.255	.254	.255		
AE	1.810	1.830		1.823	1.823	1.822	1.822		
AF	0.240	0.260		.256	.253	.253	.251		
AG	0.140	0.160		.151	.153	.151	.151		
AH	0.140	0.160		.150	.150	.150	.152		
AI	0.140	0.160		.156	.158	.157	.158		

Accept/Reject

Measured by:	P 14/11/28
Date:	

Audited by:	M.A.	DAS
Date:	14/11/29	08
		9.83

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD		Work Order:	125 924
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.483	0.490		37	38	39	40		
B	1.175	1.185		486	486	486	486		
C	3.145	3.155		1.179	1.179	1.179	1.179		
D	1.175	1.185		3.149	3.149	3.149	3.149		
E	0.365	0.385		1.179	1.179	1.179	1.179		
F	0.490	0.510		3.77	3.77	3.77	3.77		
H				.500	.501	.499	.501		
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.586	1.584	1.586	1.586		
J	0.240	0.260		.251	.251	.251	.251		
K	0.490	0.510		.500	.501	.499	.501		
L	3.590	3.650		3.615	3.615	3.615	3.615		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.259	.258	.259	.259		
O	6.500	6.520		6.510	6.509	6.509	6.509		
P	5.990	6.010		6.002	6.001	6.001	6.002		
Q	2.820	2.830		2.824	2.824	2.825	2.825		
R	2.495	2.505		2.499	2.499	2.500	2.500		
S	2.245	2.255		2.249	2.249	2.250	2.250		
T	1.120	1.130		1.124	1.124	1.125	1.125		
U	0.540	0.560		.551	.551	.551	.551		
V	0.793	0.803		.799	.798	.797	.797		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.05	.05	.05	.05		
Y	0.100	0.120		.109	.108	.110	.109		
AA	R1.125	R1.145		1.136	1.134	1.136	1.134		
AB	R.490	R.510		R.500	.500	R.500	.500		
AC	0.615	0.635		.625	.630	.630	.630		
AD	0.240	0.260		.256	.253	.252	.253		
AE	1.810	1.830		1.821	1.821	1.820	1.821		
AF	0.240	0.260		.251	.251	.251	.251		
AG	0.140	0.160		.151	.153	.152	.151		
AH	0.140	0.160		.153	.152	.151	.152		
AI	0.140	0.160		.155	.155	.155	.157		
Accept/Reject									

Measured by:	P14/11/28
Date:	

Audited by:	DAS
Date:	14/11/29
	08
	9-89

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

